

HiFill® PA6 IM 7050

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Additive	• Heat Stabilizer	• Lubricant
	• Impact Modifier	• Nucleating Agent
Features	• Heat Stabilized	• Lubricated
	• High Impact Resistance	• Nucleated
Appearance	• Colors Available	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.014	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus	280000	psi	ASTM D790
Flexural Strength	11400	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	6.0	ft·lb/in	
-4°F, 0.125 in	8.5	ft·lb/in	
73°F, 0.125 in	8.0	ft·lb/in	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	340	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	142	°F	ASTM D648
CLTE - Flow	5.3E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	460	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	490 to 555	°F
Middle Temperature	490 to 555	°F
Front Temperature	490 to 555	°F
Processing (Melt) Temp	460 to 530	°F
Mold Temperature	150 to 180	°F



Back Pressure	50.0 to 100 psi
Screw Speed	30 to 60 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

